Work Order ID 70728

Tuesday, June 14, 2011 7:49:33 AM

Item ID: D3629-1 **Accept** **Setup Start** **Stop**

Revision ID:

Item Name: Bracket

Start Date: 6/14/2011 **Start Qty:** 12.00 **Cust Item ID:**

Required Date: 6/15/2011 **Req'd Qty:** 12.00 **Customer:**

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____ **Run Start** **Stop**

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr: D3629 / Revision Nbr: Rev A									
100 Waterjet FLOW CNC Waterjet 304.063	FLOW WATER JET **Memo** 1-Cut as per Dwg D3629 ☐Dwg Rev: A ☐Prog Rev: A ☐2- Deburr if necessary	0.00 0.00				B11-6-14			
110 QC Quality Control	QC2- Inspect parts off machine FAI/FAIB **Memo**	0.00 0.00				B11-6-14			
120 QC Quality Control	QC8- Inspect parts - second check **Memo**	0.00 0.00				6 w/o 6/14			

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Run Start **Stop**

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 Small Fab Small Fab	Small Fab **Memo** 1-Bend as per dwg D3629□2-Tumble	0.00 0.00				(11)	BL-6-16	(14)	
140 QC Quality Control	QC5- Inspect part completeness to step on W/O **Memo**	0.00 0.00				11			
150 Packaging Packaging	Identify as per dwg & Stock Location: 245A **Memo**	0.00 0.00							

11/06/15

11/6/16

11/6/16 (14) SP

Work Order ID 70728

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Revision ID:

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Start Date: 6/14/2011 **Start Qty:** 12.00 **Cust Item ID:**

Required Date: 6/15/2011 **Req'd Qty:** 12.00 **Customer:**

Reference:

Run Start **Stop**

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC21- Final Inspection - Work Order Release	0.00					11/6/16		
QC	**Memo**	0.00							
Quality Control									

MF
11-06-16

Picklist Print

Tuesday, June 14, 2011 7:49:30 AM

Work Order ID: 70728

Parent Item: D3629-1

Parent Item Name: Bracket

Start Date: 6/14/2011 **Required Date:** 6/15/2011

Start Qty: 12.00 **Required Qty:** 12.00

Comments: IPP Rev:A New Issue 07-07-24 ec Verified By:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA 304/316 Sheet .063		Purchased	No			100	sf	119.1000	0.075	0.947368	1, B11-6-14		

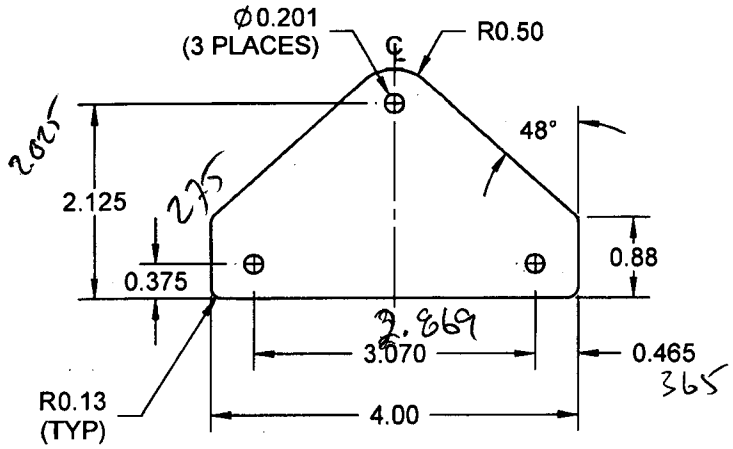
Location	Loc Qty	Loc Code
MAT020	119.1	
117275	4.3	
117653	114.8	

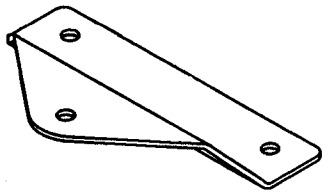
117275

DESIGN	DRAWN BY	**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA
CHECKED PH	APPROVED	DRAWING NO. D3629 REV. A SHEET 1 OF 1
DATE 07.05.10		TITLE BRACKET SCALE 1:2

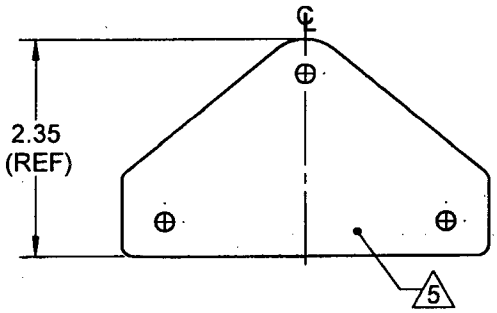
REV	DATE	DESCRIPTION
A	07.05.10	NEW ISSUE

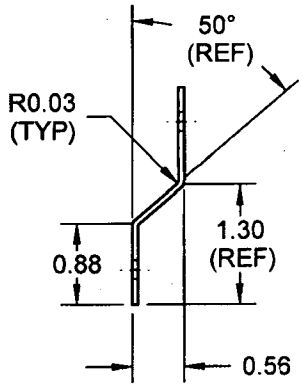
RELEASED
07.07.11





⚠1 D3629-1F BRACKET FLAT PATTERN





D3629-1 BRACKET
(MAKE FROM D3629-1F)

NOTES:
1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET (0.063 THICK, REF)
PER MIL-S-5019 (ANNEALED) 2B FINISH (REF. DART SPEC. M304S16GA)
2) FINISH: NONE
3) PART IS SYMMETRIC ABOUT ℄
4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
5) IDENTIFY WITH DART P/N "D3629-1" USING FINE POINT PERMANENT INK MARKER
6) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
7) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

DART AEROSPACE LTD	Work Order:	10728
Description: Bracket	Part Number:	D3629-1
Inspection Dwg: D3629 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

[X] First Article [ ] Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.201	+0.005/-0.001	.202	✓		V FBQZ	
0.88	+/-0.030	.88	✓		V	
0.465	+/-0.010	.465	✓		V	
0.375	+/-0.010	.374	✓		V	
3.070	+/-0.010	3.074	✓		V	
4.00	+/-0.030	3.997	✓		V	
2.125	+/-0.010	2.126	✓		V	

Measured by:	FB
Date:	11-6-14

Audited by:	
Date:	11/06/14

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.05.09	New Issue	KJ/DD	